

Work Order ID 127402

December-17-14 1:22:37 PM

127402

Page 1

Item ID: D2586 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Latch
Start Date: 12/17/14 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 12/17/14 Req'd Qty: 25.00 ***25*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 14-12-22 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2586	Rev E

100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>26999</u>								
	Possible Supplier: Southco, P/N: C2-32-25 TCH Sales								
	Certification Required								

MLJ 15-01-09

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	1-Attach certification								
	2-Keep Key with latch								

SJ JAN 13 2015

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

(25) DAS
38
0.20

JAN 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					24x	DAS 28 9-89	JAN 15 2015	
Small Fab	Memo	0.00							
Small Fab	1-Drill Hole to 0.191" 2-Counterface as per Dwg D2586 3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.								
140	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
140	QC	0.00				(24)			
Quality Control	Memo								JAN 15 2015
150	Identify as per dwg & Stock Location: 840	0.00							DAS 66 9-89
150	Packaging	0.00				24x	JAN 16 2015		
Packaging	Memo								
Packaging	***Ensure key is bag with latch***								

DQA:

Date: 15/05/08



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/05/08

Work Order update only ☐

Work Order: <u>127402</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2586</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4919</u>		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				1 part is scrap because table of drill press moved and piece was damaged Re no verification picture before set up Re Training	252042 15/01/15	Scrap + destroy No replace XX	11/10 15/01/2015	DAS 30 9-89 15/01/15	TPD 15-01-15
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☒ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☒ Other
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	<u>No verification picture</u>
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 15-01-16

(15-1-16)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Design									
Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:22:37 PM

Page 1

Work Order ID: 127402

127402

Parent Item: D2586

D2586

Parent Item Name: Door Latch

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP E02.01.31Added Inspect level 21NG IPP RevF: add not to
keep key with latch DD 10.02.10 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
C23225 *C23225* DOOR LATCH		Purchased	No			110	Each	0.0000	1	<u>2624</u>	DAS 28 9-89	JAN 15 2015	
D3015-7 *D3015-7* Lock Nut		Manufactured	No			130	Each	54.0000	1	<u>524</u>	DAS 28 9-89		

Location

Loc Qty

Loc Code

ST015

54

108429

3

120288

51

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

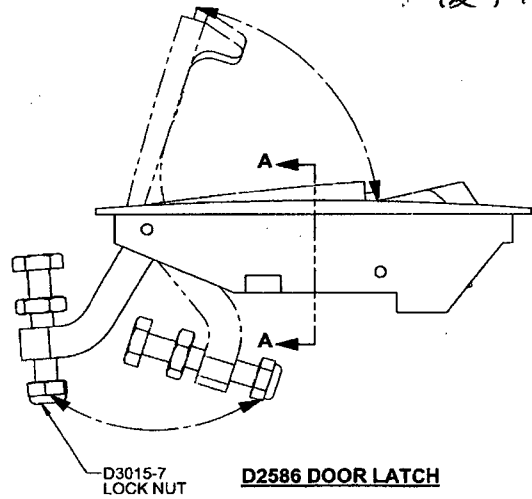
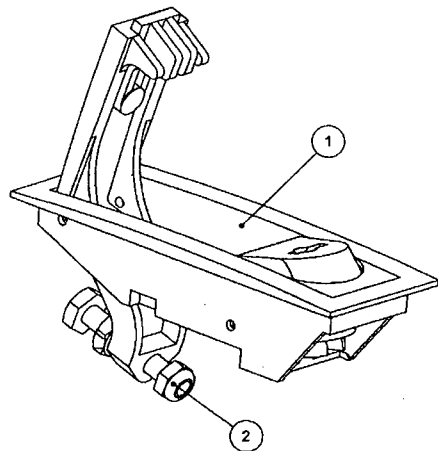
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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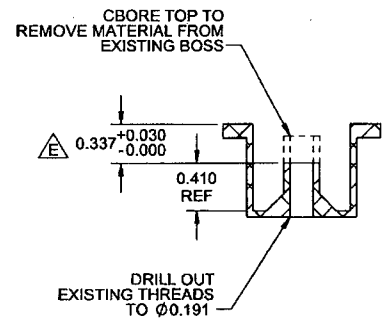
8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D2586	LATCH ASSEMBLY
1	1	C2-32-25	LATCH
2	1	D3015-7	LOCK NUT



D2586 DOOR LATCH

127402 MLS
14-12-22



SECTION A-A

RELEASED
2011-07-04

- NOTES:**
 1) MATERIAL: PURCHASE FROM SOUTHCO
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.15 lbs APPROX

E	REFORMAT. ZONE B3 UPDATED DIMENSIONS FOR CBORE. (SEE CAR 11-32)	AJS	11.08.13
D	ADD 3015-7 P/N; UPDATE DRAWING	CB	06.10.19
C	REVISED CBORE DEPTH	KE	97.09.03
B	CHANGED CBORE DEPTH	KE	97.07.23
A	NEW ISSUE	KE	96.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2586	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH	NTS
DATE	11.06.13	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26999

Purchase Order Date 1/9/2015

PO Print Date 1/9/2015

Page Number 1 of 1

Order From :

VC-TCH001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

TCH SALES INC.
C/O TH1212
PO BOX 4290 STN A
TORONTO, ON M5W 0E1
CA

FAKED

Contact Name

Vendor Phone 416 299 0089

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	C23225 AS PER DWG D2586 REV. E B127402	DOOR LATCH	1/16/2015 Yes 1/16/2015		25.00 Each	\$16.00	\$400.00
Line Total:							\$400.00
2	71401-45 PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A025 CERTIFICATE OF CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT	PROCUREMENT QUALITY CLAUSES	1/16/2015 No 1/16/2015		1.00	\$0.00	\$0.00
Line Total:							\$0.00
PO Total:							\$400.00

SP15-01-13

V ML5 CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 1/9/2015

T.C.H. Sales Inc.
 40 Emblem Court
 Toronto, Ontario M1S 1B1
 Phone: 1-800-465-6281
 Fax: 1-855-299-3214



PACKING SLIP

VENDOR	
DUNS #	242445328
TAX #	R105150197

CUSTOMER NUMERO DU CLIENT	STORE NUMBER NUMERO MARCHE	DEPARTMENT DIVISION	CUSTOMER PO COMMANDE DU CLIENT	ORDER COMMANDE	PACK NUMBER SON OF EMERSON	SOI NUMBER	PICK # NUMERO PICK	A/R TERMS A/R TERMES	PAGE PAGE
22428			26999	136039	159514		178799	NET 30	1

**S V
O E
L N
D D
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O A**
 DART AEROSPACE LTD.
 1270 ABERDEEN STREET
 HAWKESBURY ON K6A 1K7

**S E
H X
P I
D I
T I
E R
A**
 DART AEROSPACE LTD.
 1270 ABERDEEN STREET
 HAWKESBURY ON K6A 1K7
 CAN

TEL: 613-632-9577

SHIP TERM CODE DE TRANSIT	SHIP VIA TRANSHAIRE	TRACER NUMERO DE TRACER	PACK QTY DATE DE PAQ	DATE DE PAQ	DATE DE PAQ	DATE DE PAQ	DATE DE PAQ
COLL	FEDERAL EXPRESS	721023451890	01/12/15	12/31/16	1	12	

PRODUCT CODE CODE DU PRODUIT	DESCRIPTION DESCRIPTION	ORDERED COMMANDE	PACK ORDERED PAQ COMMANDE
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C23225

BLK LEV LATCH RAISED TRIG W/LK
 C2-32-25
 DOOR LATCH

25

25

0

CERTIFICATE OF COMPLIANCE

This is to certify that the items identified herein have been produced in accordance with applicable instructions, specifications, drawings, approved samples and/or other descriptions set forth in the Purchase Order.

Rajesh CRAJ
 Signature

25

25

0

Visit Us Online

www.tchweb.com

Conditions Of Sale:
 All shipments FOB Scarborough, Ontario.
 All returns are subject to a 15% handling charge and must be authorized.

Conditions De Vente:
 Tous les retours de marchandises sont soumis a des frais de manutention de 15% et a l'autorisation.